



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3312
Job Sheet 168228



Part No: 646.3312

Job Qty: 8 ea

Part Name: Center Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/28/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/16 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	11/27/17	11/27/17	0.00	0.00	Start Up Machining		17/12/15
100	Bandsaw	8 pcs	11/27/17	11/27/17	0.00	0.06	Bandsaw1		17/12/15
110	CNC Vertical Machining	8 pcs	11/28/17	11/28/17	0.29	5.99	HAAS 1		17/12/24
120	QC	8 pcs	11/28/17	11/28/17	0.00	0.00	QC1		17/12/24
130	QC	8 pcs	11/28/17	11/28/17	0.00	0.00	QC8		18-01-07
131	HandFinish	8 pcs	11/28/17	11/28/17	0.00	0.00	HandFinish2		
140	Outsource	8 pcs	11/28/17	11/28/17			ATG001-VC		
150	Packaging	8 pcs	11/28/17	11/28/17	0.00	0.00	Packaging2		DAS
155	QC	8 pcs	11/28/17	11/28/17	0.00	0.00	QC5		38
180	Packaging	8 pcs	11/28/17	11/28/17	0.00	0.00	Packaging3	CK102	AT18/09/24
190	QC21-SA	8 Ea	11/28/17	11/28/17	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 16.300" *** ONE BLANK MAKES TWO PARTS***

Descriptions: 110 - 1-Machine per folio FB153 3-Face to .375" if required

120 - Inspect on CMM as per folio CMMA027.

140 - Issue P/O to ATG :

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

HARD ANODIZE color Black;
Prime as per Dwg 646.3312

DAS
21

JAN 24 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6B5.000X0.375	5	0	0	0

Part Specifications

Specifications could not be found.

FM138563-1X1 3022482
3017359X3 3022485

Plex 11/13/17 4:19 PM dart.boucher.sylvie

DART
AEROSPACE
S022498



Center Plate

PART NO: 646.3312
Original Serial #: S022498
Revision:
Operation: Outsource
Change No:

Mfg Date: 12/14/17
Job No: 168228

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE
S022498



Center Plate

PART NO: 646.3312
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/14/17
Job No: 168228

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DQA: _____ Date: _____



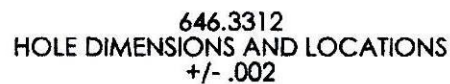
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



NOV 16 2017

[illegible]

DQA: _____ Date: _____

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Misidentified ☐	Past Due ☐																																																																

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03724				SHEET 1 OF 1	
	DWG NO. 646.3300		REV: N/C	PREPARED BY: B. PETERS	DATE: 12/05/12	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: UPPER CUTTER ASSY					
APPROVED BY: <i>[Signature]</i>		ENGR: <i>[Signature]</i>	MFG: <i>[Signature]</i>	QC: <i>[Signature]</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED ORDINATE DIMENSION.				ECR: D-12-025

1 10.338
2 10.086
3 9.374
4 8.929
5 8.815
6 8.221
7 8.815
8 5.836
9 5.216
10 5.163
11 5.122
12 5.027
13 4.893
14 4.836
15 4.752
16 4.159
17 2.690
18 2.471
19 2.890
20 2.471
21 2.890
22 2.471
23 2.890
24 2.471

Ø .177 THRU SPL

R.125

R.295

11 Ø .200 THRU

12 .890
13 .471

14 .313
15 1.000
16 1.110
17 1.250
18 1.350
19 1.410
20 1.537
21 1.656
22 1.777
23 1.977
24 2.156
25 2.256
26 2.519
27 2.631
28 2.737
29 3.800

17.720

5.266

IS

SHEET 4, ZONE B8 IS:

DOCUMENTS EFFECTED:	☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY	☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED	☐ YES ☒ NO
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QA Closed: _____		Date: _____		Work Order update only ☐																																																																																																				
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Tel (613) 632-5200

PURCHASE ORDER PO038727

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	168031	647.3916	Splice Plate Issue P/O _____ATG, black anodize and prime as per dwg 647.1612 Rev. A Deflector Issue P/O to ATG :	Firmed	1/30/17	2 pcs	0 pcs	2 pcs	\$18.80/pcs	\$37.60
9	168033	647.4114	Hard Anodize Color Black, Prime as per Dwg 647.3900 Rev. C Shim Issue P/O _____ATG, black anodize and prime as per dwg 647.4114 Rev. N/C	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$6.95/pcs	\$69.50
10	168034	647.4115	Shim Issue P/O _____ATG, black anodize and prime as per dwg 647.4115 Rev. N/C	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$6.95/pcs	\$69.50
11	169394	647.7913	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 647.7913 Rev. A	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$8.10/pcs	\$81.00
12	168215	646.2910	Deflector Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	1/30/17	2 pcs	0 pcs	2 pcs	\$48.70/pcs	\$97.40
13	168247	646.3717	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 646.3717 Rev. A	Firmed	1/30/17	20 pcs	0 pcs	20 pcs	\$6.95/pcs	\$139.00
14	168248	646.3718	Custom Washer Issue P/O _____ATG, black anodize and prime as per dwg 646.3718 Rev. A	Firmed	1/30/17	40 pcs	0 pcs	40 pcs	\$4.65/pcs	\$186.00
15	168249	646.3719	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 646.3719 Rev. A	Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$6.95/pcs	\$83.40
16	168251	646.3811	Radius Block Issue P/O _____ATG, black anodize and prime as per dwg 646.3811 Rev. A	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$7.25/pcs	\$72.50
17	168228	646.3312	Center Plate Issue P/O to ATG :	Firmed	1/30/17	8 pcs	0 pcs	8 pcs	\$12.75/pcs	\$102.00



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914461

Date: 22-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 646.3717 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22303		Rev: A PO: PO038727 Line: 13
40 ea	Part: 646.3718 Custom Washer Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22304		Rev: A PO: PO038727 Line: 14
8 ea	Part: 646.3312 Center Plate Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22307		Rev: N/C PO: PO038727 Line: 17
15 ea	Part: 647.0116 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22295		Rev: A PO: PO038727 Line: 5
12 ea	Part: 647.1612 Splice Plate Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6		Rev: A Made in Canada.

Made in Canada.